

Date: Monday, 11/6/2006 2:39:30 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 29334
 Estimate Number : 10608
 P.O. Number : N/A Part Number : D2655
 This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2655 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 28958 Material : N/A
 Due Date : 11/22/2006 Qty: 30 Um: Each
 Written By : JA 06 11 07
 Checked & Approved By : JA 06 11 07
 Comment : Est. D 0006.22 Removed P/O for powder coat EC
 Est Rev:E Now on Waterjet 06-10-04 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018B400X250 Inventory



Comment: Qty.: 0.2835 f(s)/Unit Total : 8.5050 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: M102372

JA 06 11 07

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: B

Prog Rev: B

JA 06 11 07

(30)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 06 11 07

(30)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JA 06/11/07

(30)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

FF 06-11-21

30

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RING

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Part Number: D2655

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/11/21

(30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 02/11/23

(30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST140

PV 6/11/24

(30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/27

Job Completion



U 06/11/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

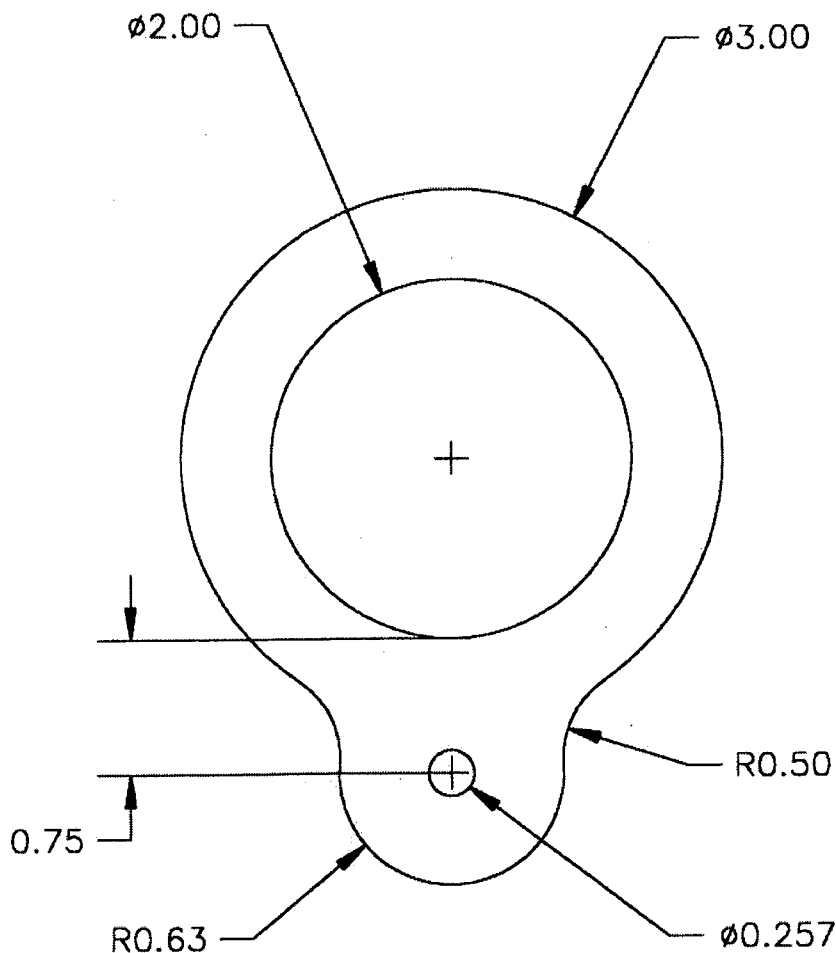
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47 07 14 DS

NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO
ENGINEERING

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WORK ORDER
NO. 29334